

Work Order ID 79999


January-30-12 9:43:20 AM

shg today

79999

Page 1

Item ID: D4170-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bushing
 Start Date: 1/30/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/30/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4170	B								

100 Hardinge CNC LATHE SMALL 0.00
 100
 Hardinge
 Hardinge CNC Lathe Small
 Memo
 Machine as per Folio FA989
 FOLIO REV: _____
 DWG REV: _____
 DEBURR Manual
 12/01/30 4

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC
 Quality Control
 Memo
 12/01/30 4

Work Order ID 79999

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January-30-12 9:43:20 AM

Item ID: D4170-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 1/30/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/30/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		Rq 12-1-30		4	6		
125 *125* Skidtubes Skidtubes	Memo 1- clean crossbolt spacer with ultra brigh aluminum cleaner before storing.	0.00 0.00		N/A giv info D350636-047 kit					
130 *130* Packaging Packaging	Identify as per dwg & Stock Location ST35 Memo ***STOCK IN SKIDTUBE CELL***	0.00 0.00							SD 2-01-30

79999

January-30-12 9:43:20 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 1/30/12 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/30/12 **Req'd Qty:** 4.00 ***4***

Customer:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

140

QC

Memo

0.00

Quality Control

20130
(4)

Picklist Print

January-30-12 9:43:20 AM

Page 1

Work Order ID: 79999

Parent Item: D4170-3

Parent Item Name: Bushing

Start Date: 1/30/12

Required Date: 1/30/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD IPP Rev:A 10.11.02 as per
revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	176.5080	0.275	1.1578947			

Location

Loc Qty

Loc Code

MAT012

176.508

114488

1.997

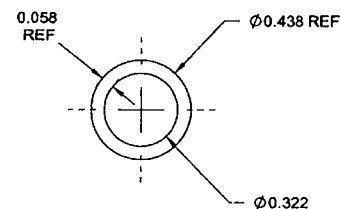
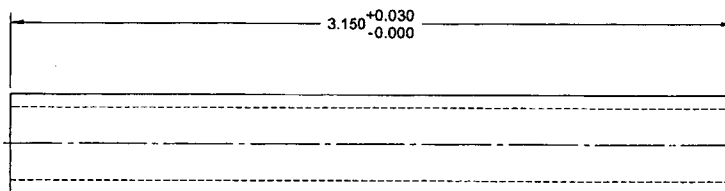
117379

9.288

119043

165.223

1.15 ~~9.0~~ 12/01/30



D4170-3 SPACER

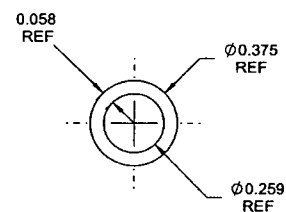
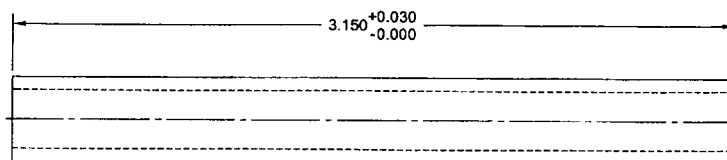
w/079999

RELEASE
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, $\phi 7/16$ OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
OR
6061-T6 OR 6061-T62 TUBING, $\phi 7/16$ OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO. D4170	REV. B
MFG. APPR.	<i>JP</i>	SHEET 2 OF 2	
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SPACER	NTS
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D4170-1 SPACER

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, $\phi 3/8$ OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

B	ADD -3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4170	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACER	NTS
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DART AEROSPACE LTD		Work Order:	79999
Description:		Part Number:	4170-3
Inspection Dwg:		Rev:	4170, B

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
3.150		± 0.030	3.167	—	—	R426	dem
.438		± 0.010	.439	—	—	R426	
Ø.322		± 0.005	0.324	—	—	"	
.058		± 0.010	.055	—	—	"	

Measured by:		Date:	12/01/30
Audited by:	R9	Date:	12.1.30
Prototype Approval:		Date:	

Rev	A	Date	Change

Revised by	KJ/JLM	Approved
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